

Work Order ID 62814

Friday, October 08, 2010 12:45:26 PM



Page 1

Item ID: D3651-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Inside Doubler

Start Date: 10/8/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 10/10/08

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3651

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3651 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

304 . 018

B10-10-28

E/B 10/10/28

(6)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-10-28

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 10/10/28

(x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62814

Friday, October 08, 2010 12:45:26 PM



Page 2

Item ID: D3651-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Inside Doubler

Start Date: 10/8/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location

188

0.00



Packaging

Memo

0.00

Packaging

10/10/09 SP (6x)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/01 JF
BSO-10-01
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, October 08, 2010 12:45:30 PM

Page 1

Work Order ID: 62814



Parent Item: D3651-9



Parent Item Name: Inside Doubler


Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA  304/316 0.018 SHEET		Purchased	No			110	sf	144.0000	0.431	1.814737	2.6		



BW-10-28

Location

Loc Qty

Loc Code

MAT20

144

109398

48

112885

96

109398

①

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	62814
Description: Inside Doubler		Part Number:	D3651-9
Inspection Dwg: D3651 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.25	+0.004/-0.001	0.254	x		V HB02	
0.250	+/-0.010	0.250	x		V	
0.500	+/-0.010	0.500	x		V	
6.33	+/-0.030	6.335	x		✓	
9.81	+/-0.030	9.801	x		V PRO HB02	
2.818	+/-0.010	2.816	x		V	
2.100	+/-0.010	2.095	x		V	
2.100	+/-0.010	2.099	x		V	
2.575	+/-0.010	2.577	x		V	
2.000	+/-0.010	2.000	x		V	
5.514	+/-0.010	5.514	x		V	
2.750	+/-0.010	2.753	x		V	
2.200	+/-0.010	2.199	x		V	
2.371	+/-0.010	2.373	x		V	
1.325	+/-0.010	1.325	x		V	
3.112	+/-0.010	3.109	x		V	
1.400	+/-0.010	1.397	x		V	
5.514	+/-0.010	5.512	x		V	

Measured by:	IB	Audited by:	S	Prototype Approval:	N/A
Date:	10-10-29	Date:	10/10/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	AS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

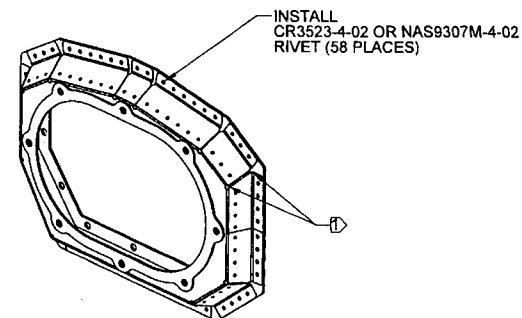
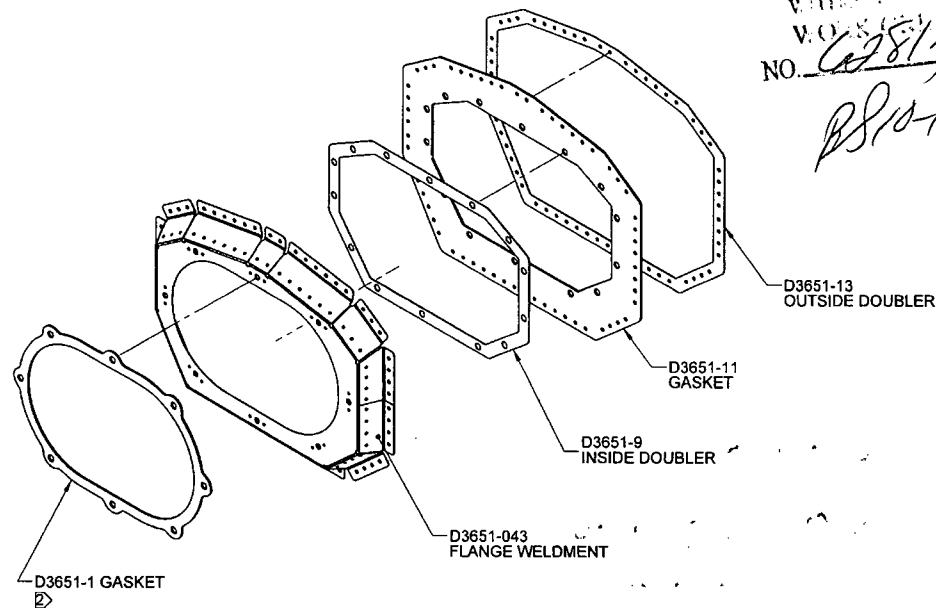
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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT: AFT BASE ASSEMBLY
VOLUME 1
WORK ORDER NO. *67817*
PS10-10-08



PART LIST

QTY	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

D3651-041 AFT BASE ASSEMBLY

D3651-041 NOTES:

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50, 0.88 WAS 0.98: REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	CE	DRAWING NO.	REV. B
MFG. APPR.	MD	D3651	SHEET 1 OF 9
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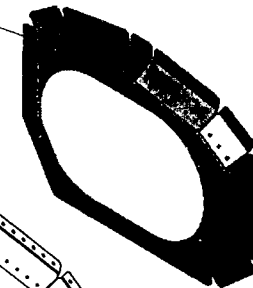
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

TRANSFER DRILL $\varnothing 0.129$ (#30 DRILL)
FROM D3651-5/-7 TO D3651-3
INSTALL CR3523-4-02 OR NAS9307M-4-02
RIVETS (57)



D3651-5
TOP FLANGE
(REF)

D3651-7
BOTTOM FLANGE
(REF)

D3651-3
BASE

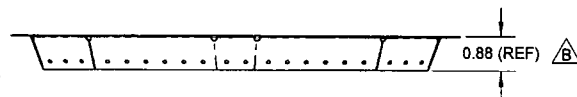
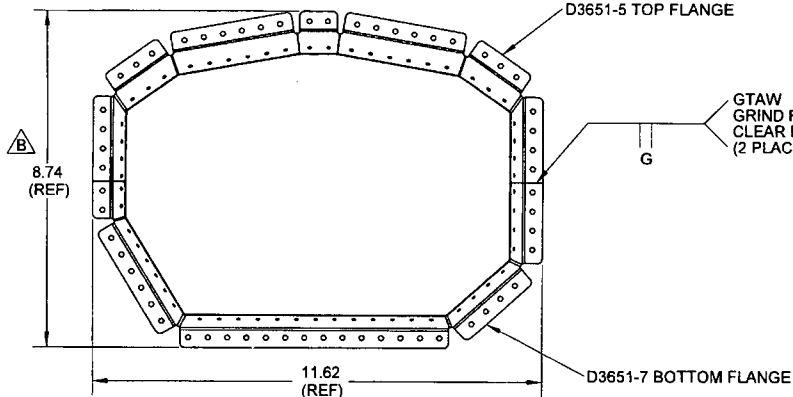
W/5 62814

MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

G
GTAW
GRIND FLAT TO
CLEAR FASTENERS
(2 PLACES)

D3651-5 TOP FLANGE

D3651-7 BOTTOM FLANGE



D3651-043 FLANGE WELDMENT

QTY -043	PART NUMBER	DESCRIPTION
X	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NAS9307M-4-02	RIVET

08.03.27.14

D3651-043 NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.76 lbs

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MFG. APPR.	UE	SHEET 2 OF 9	
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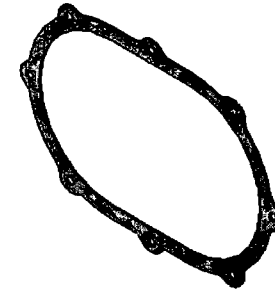
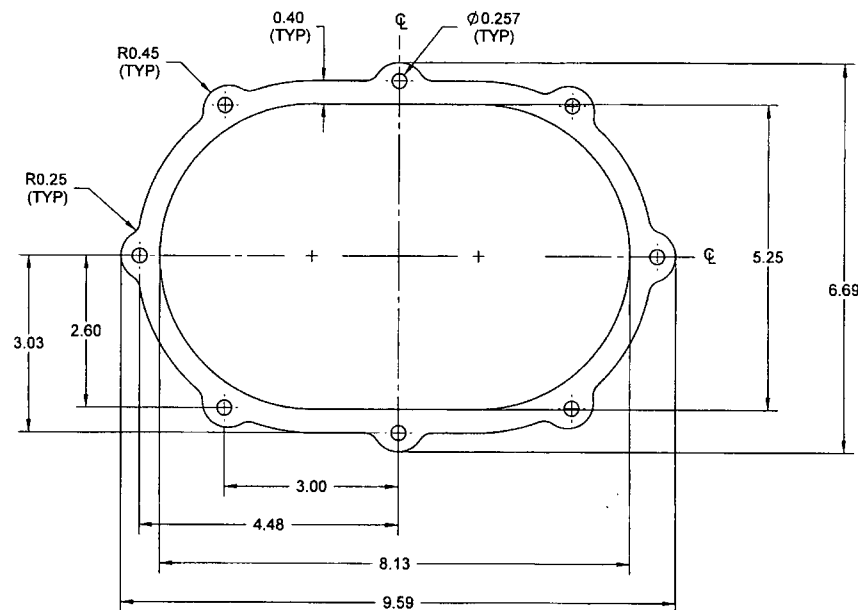
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NOTE: Date & initial all entries



u/c 62814

D3651-1 GASKET

NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) PART IS SYMMETRIC ABOUT ϕ
- 8) WEIGHT: 0.09 lbs

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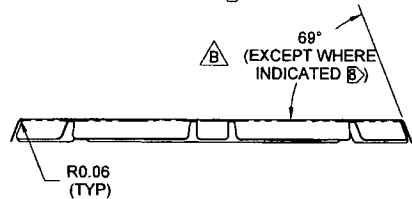
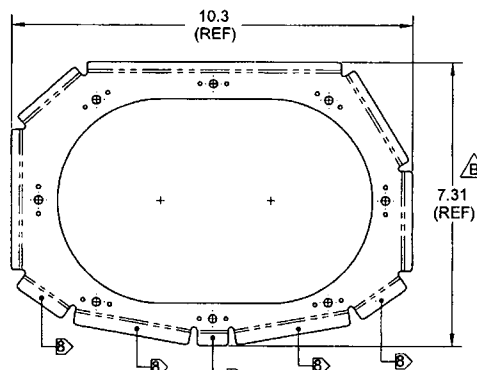
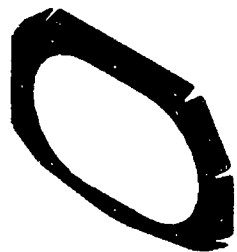
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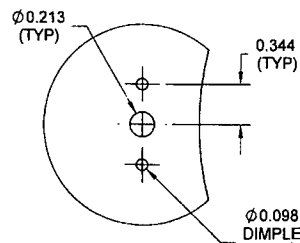
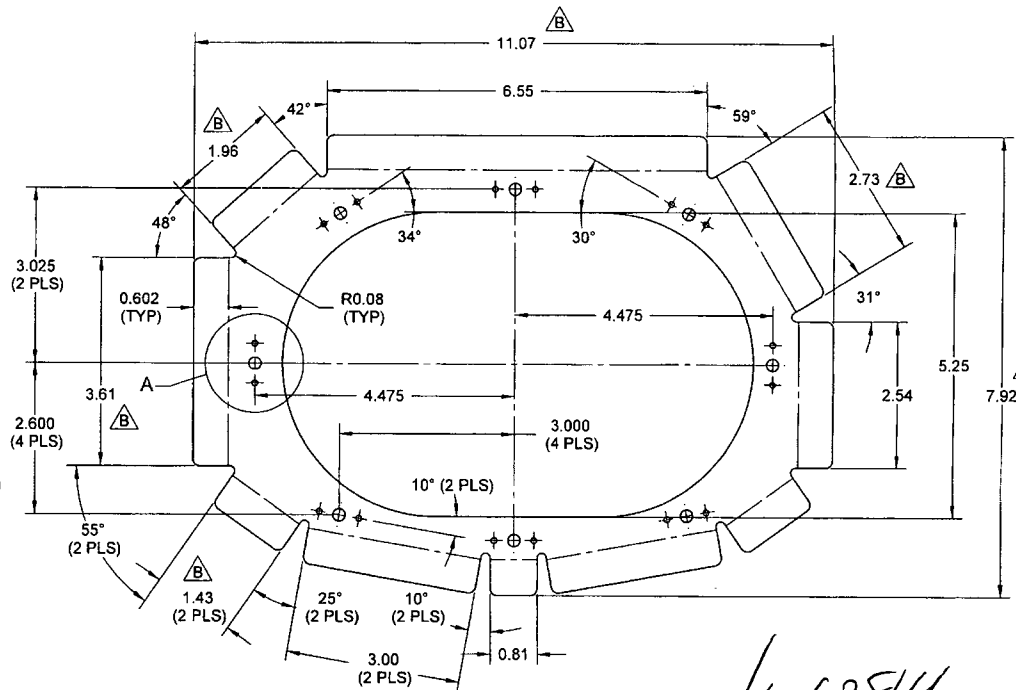
NOTE: Date & initial all entries



D3651-3 BASE
(MAKE FROM D3651-3F FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) BEND TO 55° WHERE INDICATED



DETAIL A

D3651-3F FLAT PATTERN

W/O 62814

08-03-27

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
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DATE	08.01.07		

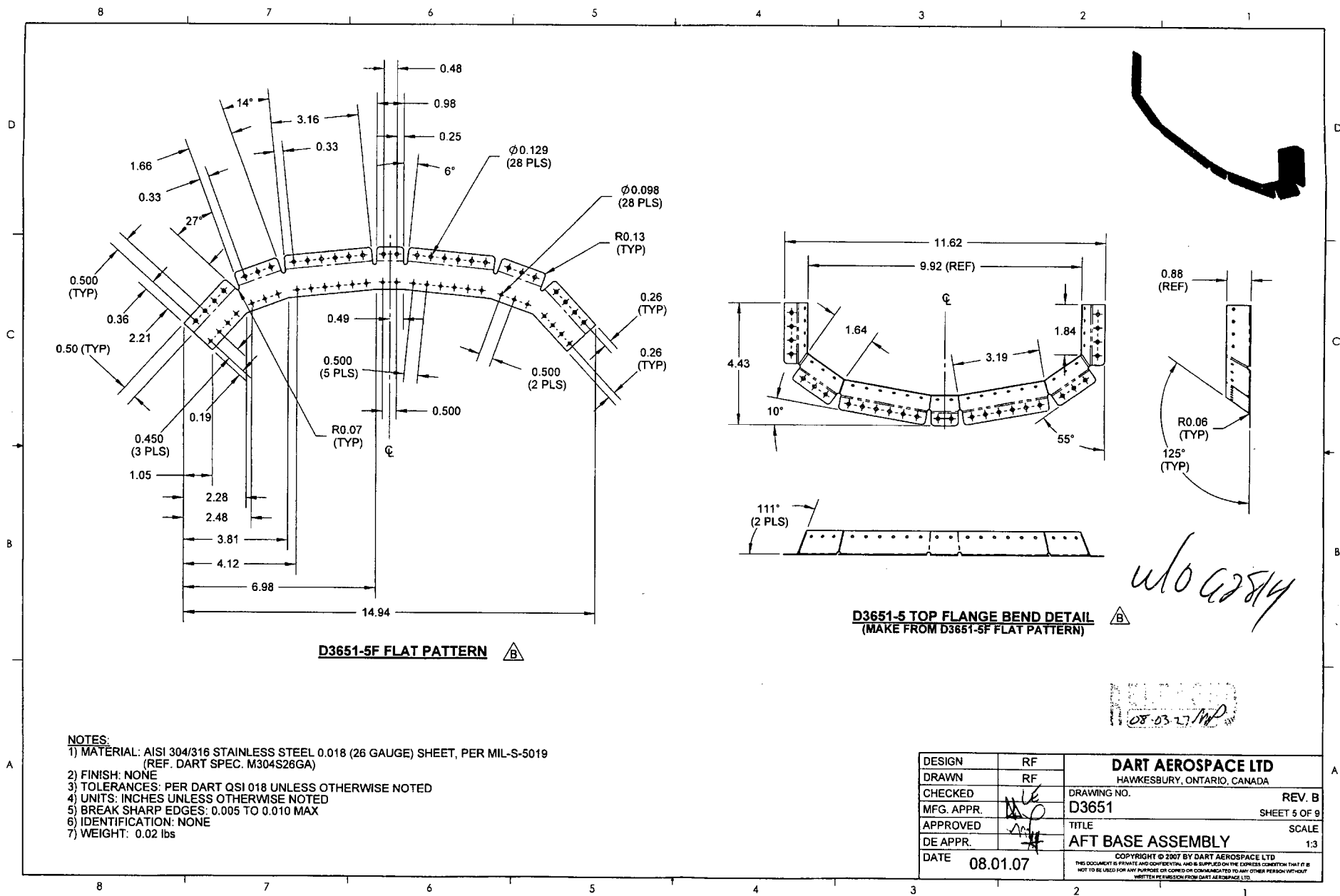
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3651-5F FLAT PATTERN

D3651-5 TOP FLANGE BEND DETAIL
(MAKE FROM D3651-5F FLAT PATTERN)

u1002814

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

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DRAWN	RF		
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MFG. APPR.	<i>[Signature]</i>	D3651	SHEET 5 OF 9
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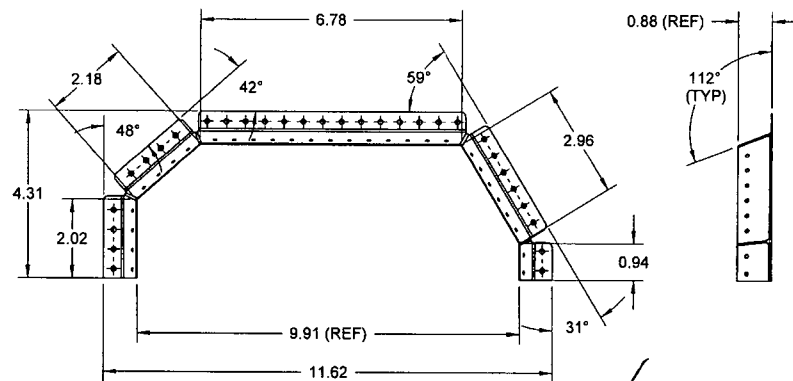
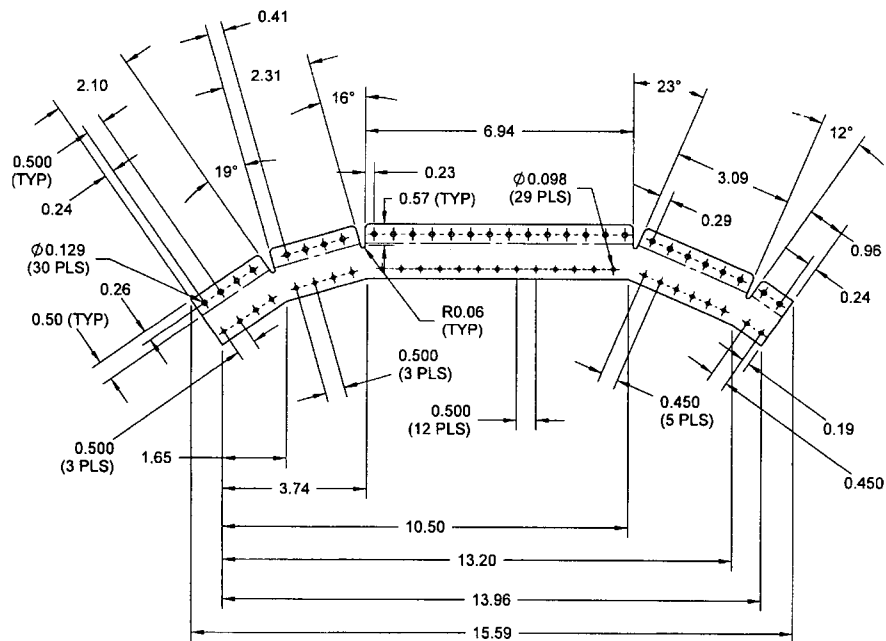
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3651-7 BOTTOM FLANGE BEND DETAIL
(MAKE FROM D3651-7F FLAT PATTERN)

D3651-7F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. B
MFG. APPR.	RF	D3651	SHEET 6 OF 9
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

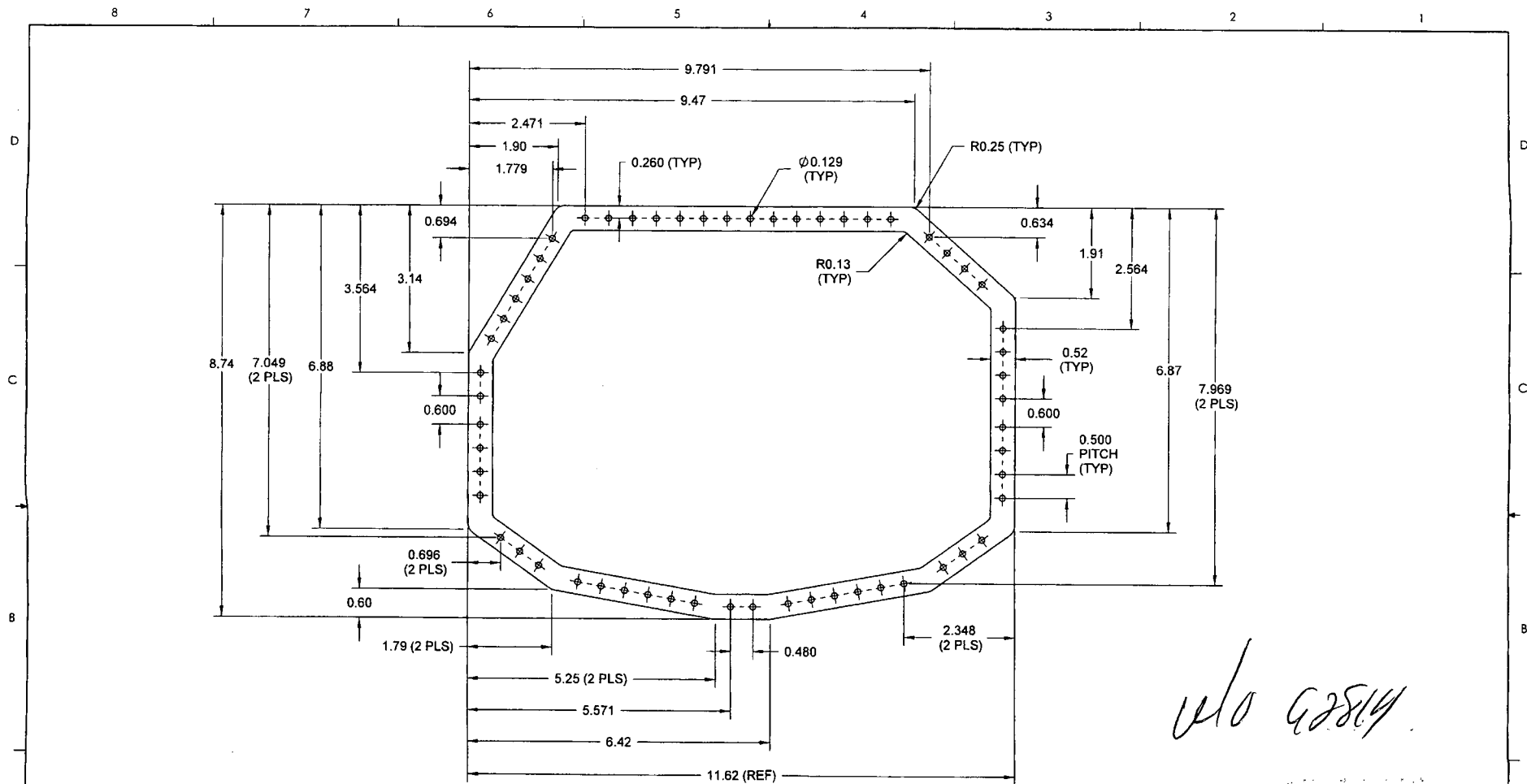
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3651-13 OUTSIDE DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3651	SHEET 9 OF 9
APPROVED		TITLE	SCALE
DE APPR.		AFT BASE ASSEMBLY	1:2
DATE	08.01.07	<small> COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

Ulo 92864

08.03.27 MP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries